



DESIGN FH	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D412-664-243	REV. B SHEET 1 OF 3
DATE 05.02.04		TITLE CROSSTUBE ASSEMBLY (412 HI AFT) NTS	
A	01.10.17	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

**RELEASED**  
05.06.09 [Signature]  
**UNDER REVIEW**  
06.10.25 [Signature]

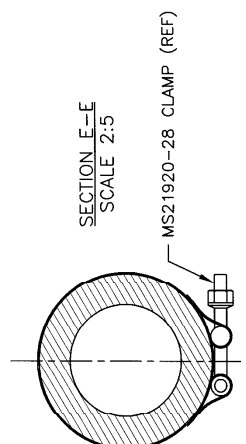
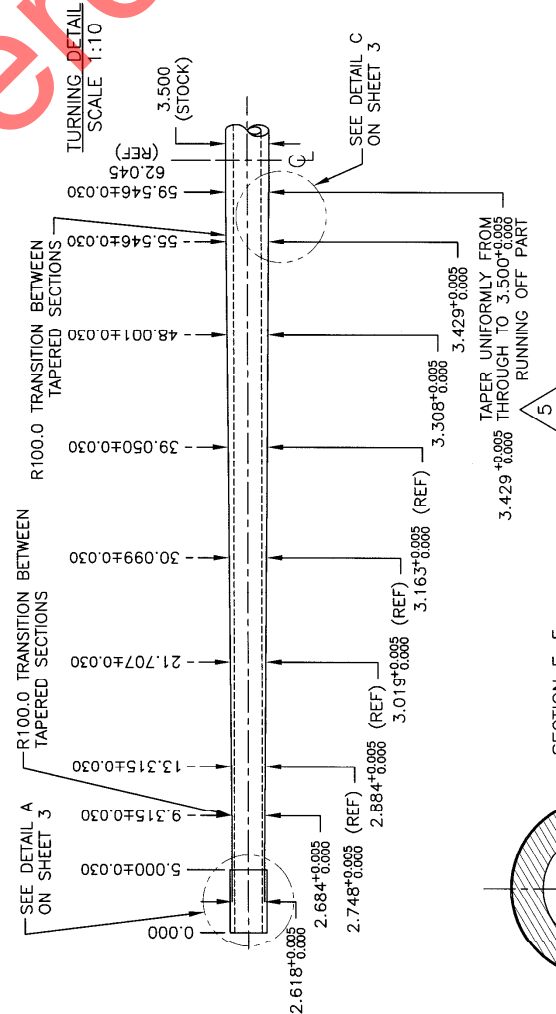
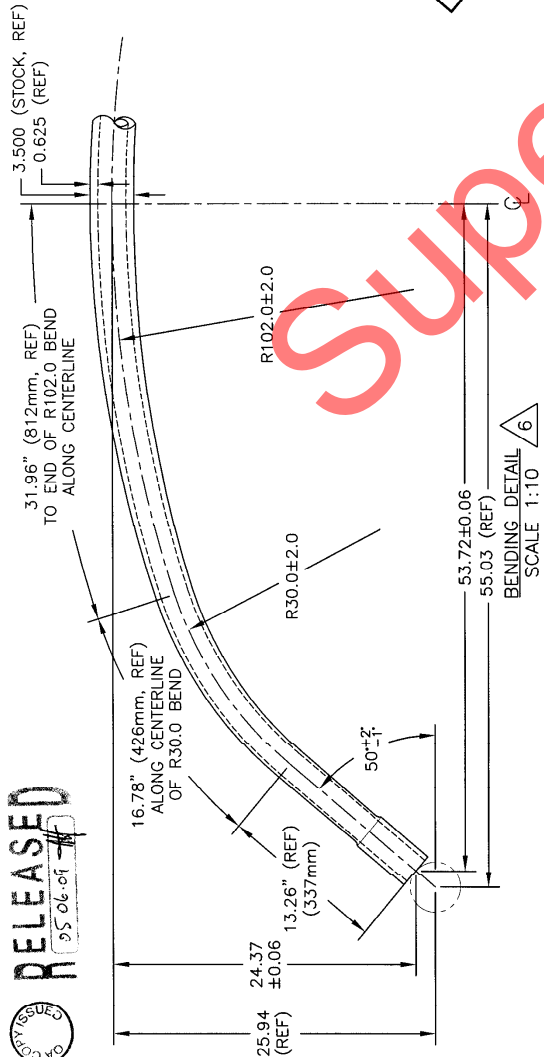
Qty	Part Number	Description
X	D412-664-243	CROSSTUBE ASSEMBLY (412 HIGH AFT)
1	D6009-129	CROSSTUBE
1	D2896-1	SUPPORT
2	D2856-600-1009	ABRASION STRIP
1	D2856-600-1087	ABRASION STRIP
4	MS21920-28	CLAMP
2	MS21920-30	CLAMP
2	D3189-1	CHAFING SHIELD

#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6009-129  
FINISHED LENGTH = 124.09±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 AND D2856-600-1087 ABRASION STRIPS WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2896-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTINAL TO TO SEAL EDGES OF SUPPORTS USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

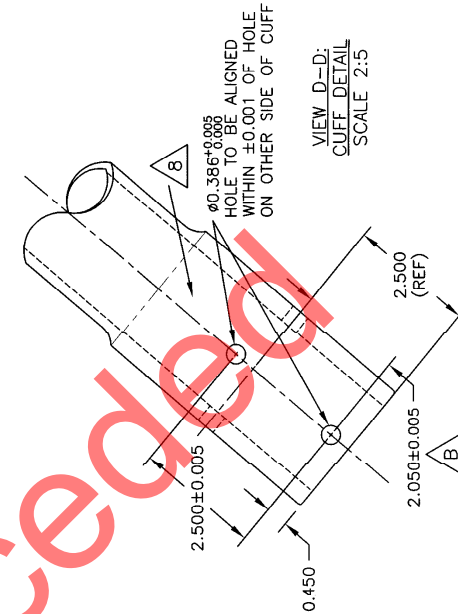
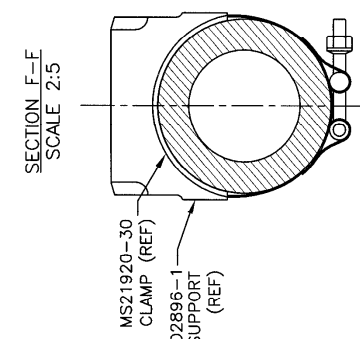
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UNDER REVIEW

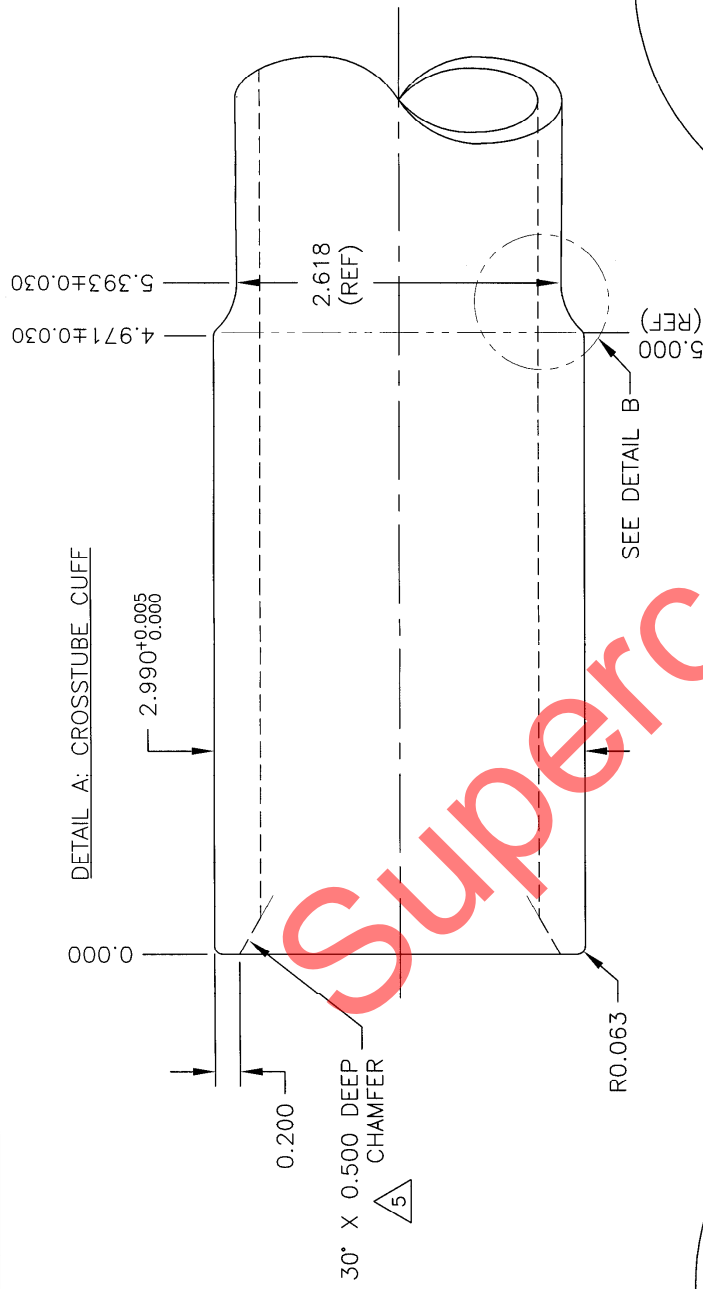
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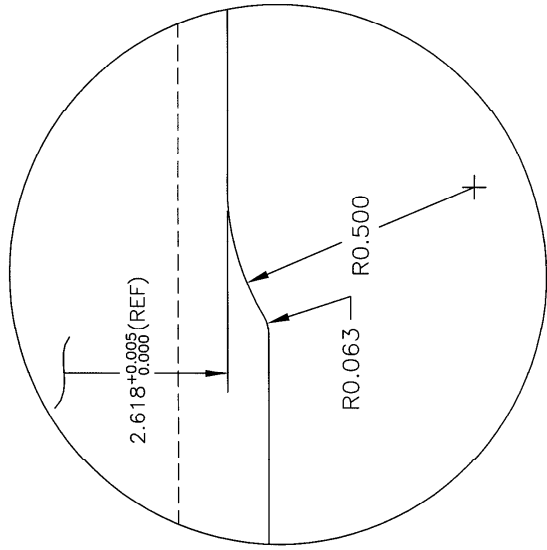
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				CHECKED	APPROVED	DRAWING NO.	REV. B
				DATE		D412-664-243	SHEET 2 OF 3
						TITLE	SCALE
						CROSSSTUBE ASSEMBLY (412 HI AFT)	1:10

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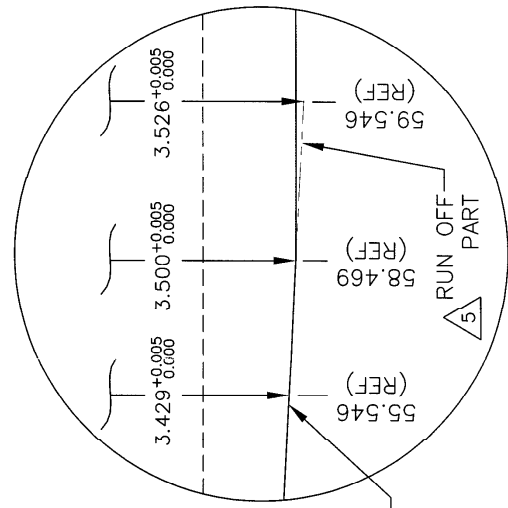
UNDER REVIEW  
06.10.25



DETAIL A: CROSSTUBE CUFF



DETAIL B: CUFF  
TRANSITION  
SCALE 4:1



DETAIL C:  
TAPER RUN-OFF  
NOT TO SCALE

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				05.02.04		CROSSTUBE ASSEMBLY (412 HI AFT)	1:1